

Work Order ID 110608

110608

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January-07-14 7:28:42 AM

Item ID: D4798-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 1/07/14 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 1/17/14 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4798	B								

100 0.00
 100
 Waterjet 5 0 Ac 14.01.07
 FLOW CNC Waterjet
 Memo
 1-Cut D4798-1 as per Dwg
 Dwg Rev: 3
 Prog Rev: 3
 2-Deburr if necessary
 110 0.00
 110
 QC 5 0 Ac 14.01.07
 Quality Control

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Item ID: D4798-041 Accept *N900040100* Setup Start *NS1*
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Item Name: Wearplate Assembly
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Required Date: 1/17/14 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 27 9.89 141117				5			
130 *130* Large Fab Large Fab	Memo ***USE DT9891 WELDING FIXTURE*** 1- Weld cups as per dwg A/R S.S. ROD BATCH: <u>m125054</u> 2- Apply hardfacing on wearplate as indicated on dwg A/R HARDCOAT 2059B BATCH: <u>m122237</u>	0.00 0.00				5	Ø		14-01-14 JBL
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				5			14-01-15

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Item ID: D4798-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 1/07/14 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/17/14 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

⑤ 14-01-15DAS
9
9-89

160

Identify as per dwg & Stock Location: 51501

0.00

160

Packaging

Memo

0.00

Packaging

5DAS
33
9-89 14-01-15

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

14-01-15④ 14-01-15

Picklist Print

January-07-14 7:28:41 AM

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Work Order ID: 110608
Parent Item: D4798-041
Parent Item Name: Wearplate Assembly
Comments: IPP REV:A NEW ISSUE 13-03-26 JLM VERIFIED BY:DD
 DWG REV.B DD VERF:JLM

Start Date: 1/07/14
Start Qty: 5.00
Required Date: 1/17/14
Required Qty: 5.00

IPP REV:B 13.05.28 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-1 Wearplate Cup		Manufactured	No				Each	43.0000		50			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		43							
						43							
M304S16GA 304/316 Sheet .063		Purchased	No				sf	338.0900		7			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		338.09							
				M126915		18.09							
				M127821		320							

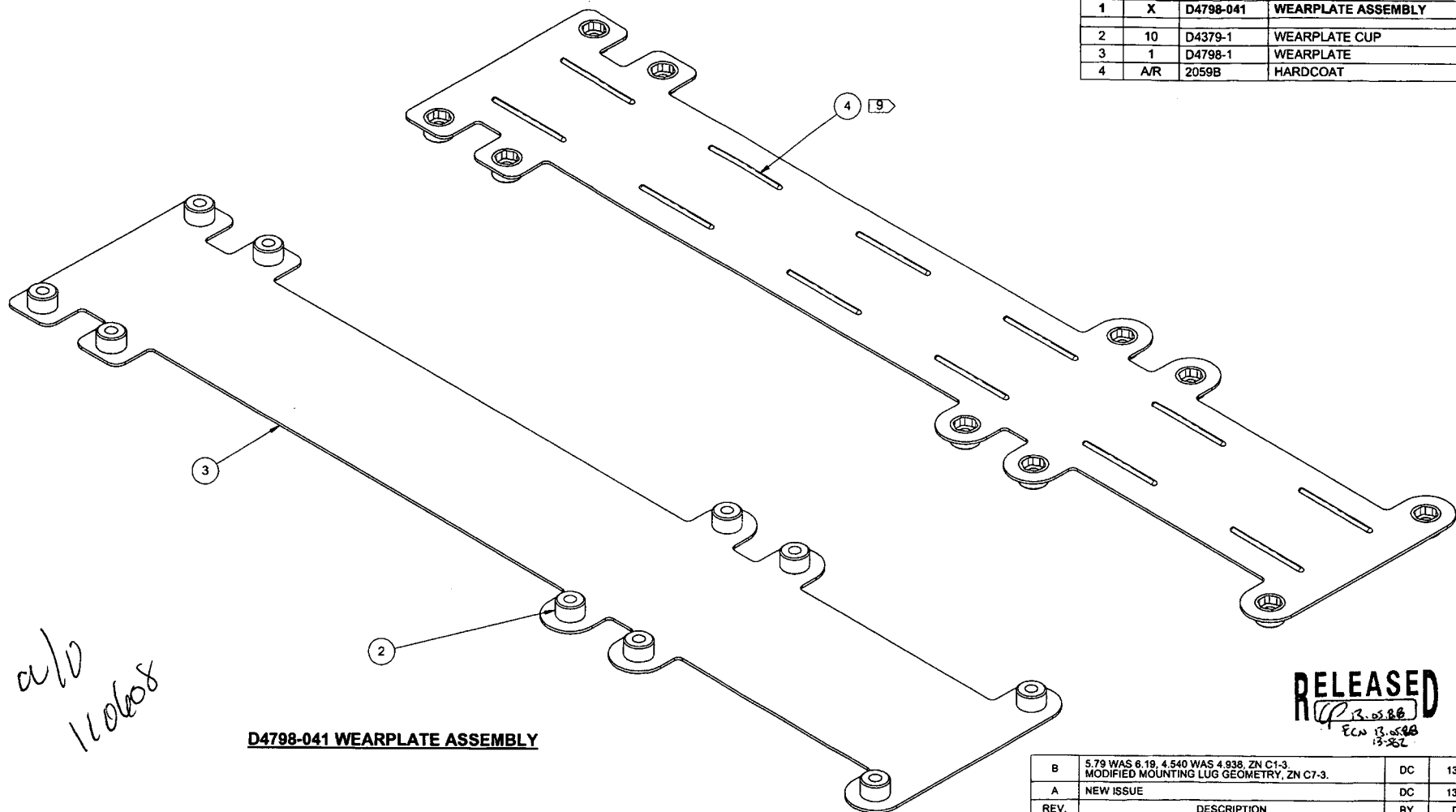
14-01-08
JBL

7
43

Ac 14.01.07

126915 → (7)

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4798-041	WEARPLATE ASSEMBLY
2	10	D4379-1	WEARPLATE CUP
3	1	D4798-1	WEARPLATE
4	A/R	2059B	HARDCOAT



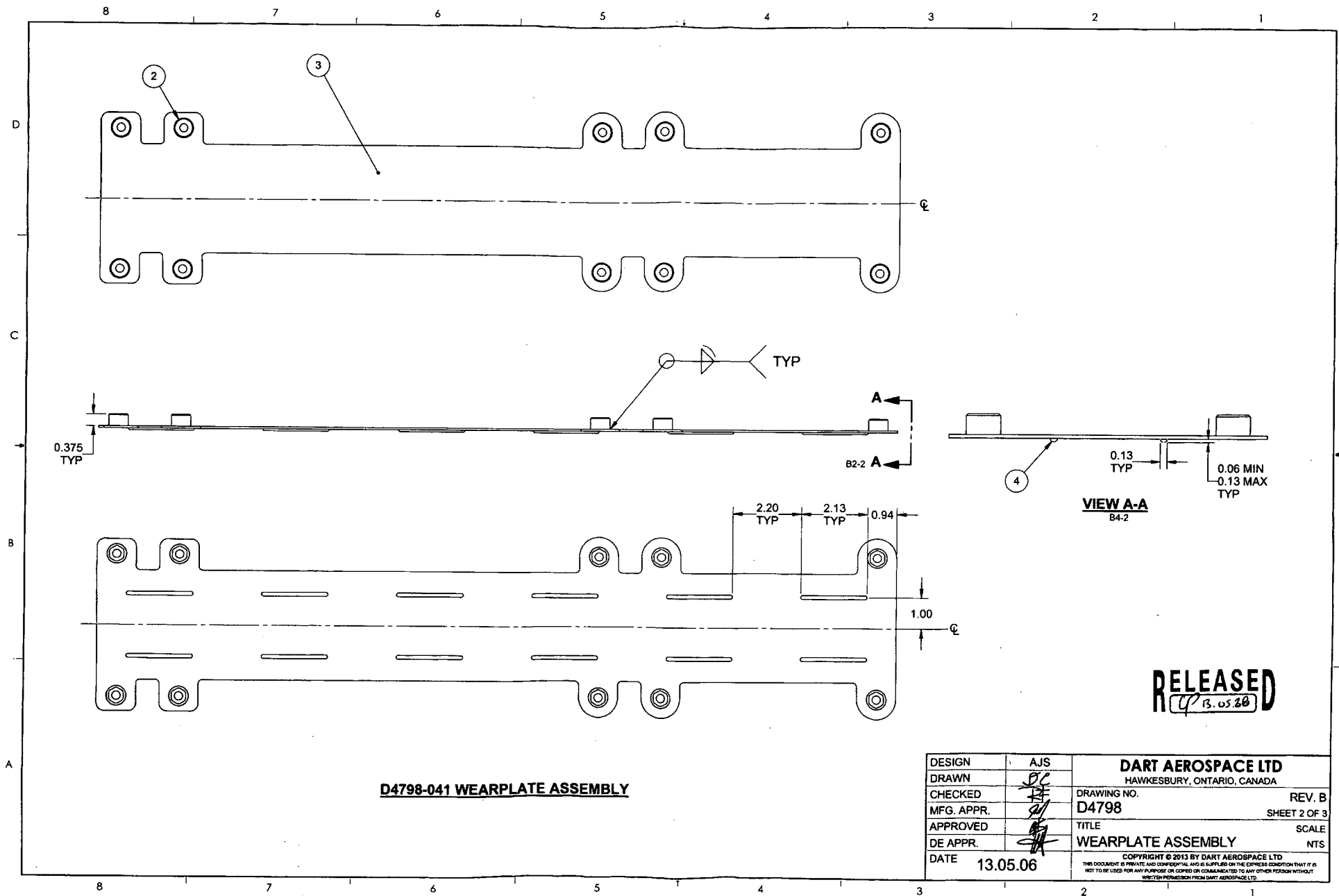
D4798-041 WEARPLATE ASSEMBLY

RELEASED
ECN 13-0588
13-562

NOTES:

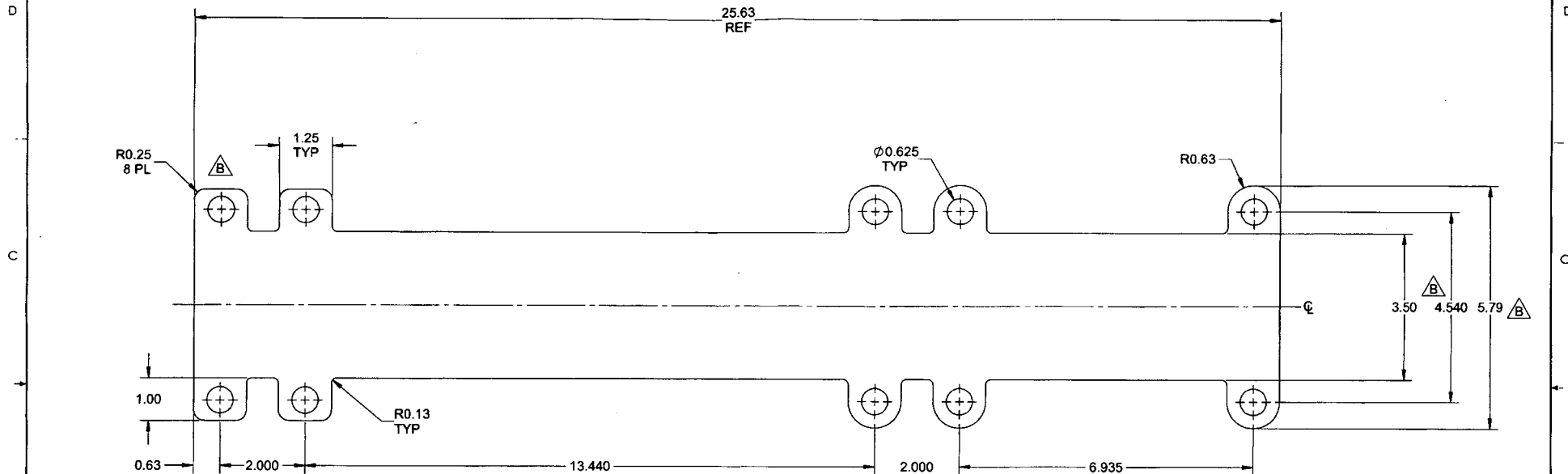
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 2.05 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B	5.79 WAS 6.19, 4.540 WAS 4.938, ZN C1-3, MODIFIED MOUNTING LUG GEOMETRY, ZN C7-3.	DC	13.05.06
A	NEW ISSUE	DC	13.03.20
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4798	SHEET 1 OF 3
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	WEARPLATE ASSEMBLY	NTS
DATE	13.05.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4798	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4798-1 WEARPLATE

RELEASED
13.05.20

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.82 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO.	REV. B
MFG. APPR.	DE	D4798	SHEET 3 OF 3
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8 7 6 5 4 3 2 1